

Date: Monday, 12/01/2009 2:29:55 PM  
User: Julie Dawson

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BRACKET ASSEMBLY	
<b>Job Number</b> :	44551			
<b>Estimate Number</b> :	10334			
<b>P.O. Number</b> :		<b>Part Number</b> :	D2804042	
<b>This Issue</b> :	12/01/2009	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2804 REV C	
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A	
<b>Previous Run</b> :	44492	<b>Drawing Revision</b> :	C	
<b>Written By</b> :		<b>Material</b> :		
<b>Checked &amp; Approved By</b> :	<u>JLD 09.01.12</u>	<b>Due Date</b> :	30/01/2009	<b>Qty:</b> 4 <b>Um:</b> Each
<b>Comment</b> :	Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM Est Rev:G As per Rev C 06-11-08 JLM			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D28042	Bracket
-----	--------	---------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
STA 155 Bracket

Pick:

Qty	Part Number	Description	Batch
1	D2804-2	Bracket	B44476

2.0	D28052	Stop
-----	--------	------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Stop

Pick:

Qty	Part Number	Description	Batch
1	D2805-2	Stop	41707

3.0	D2809	Bushing
-----	-------	---------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bushing

Pick:

Qty	Part Number	Description	Batch
1	D2809	Bushing	28917 40929

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
Press D2805-2 into arm as per Dwg D2804

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 12/01/2009 2:29:55 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 44551

Part Number: D2804042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

090123 (4)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

8:30

OVEN TEMPERATURE:

320°

FINISH TIME:

9:30

FL 09/01/26

(4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

090127 (4)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press Fit D2809 as per Dwg D2804

090127 (4)

090126 (4)

9.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2

AN3C16A

Bolt

M107737  
M109147

09/01/27 (4)

10.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Pick:

Qty Part Number

Description

Batch

2

MS21043-3 Nut

M110023

09/01/27 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 12/01/2009 2:29:55 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 44551

Part Number: D2804042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Pick:

Qty Part Number Description

Batch : 4 NAS1515H3

Washer

A/R LPS-3

Corrosion Spray

SS 09/01/27 (4)

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

SS 09/01/27 (4)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/01/27 (4)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 159

9/1/27

(4)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/28

Job Completion



u 09/01/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

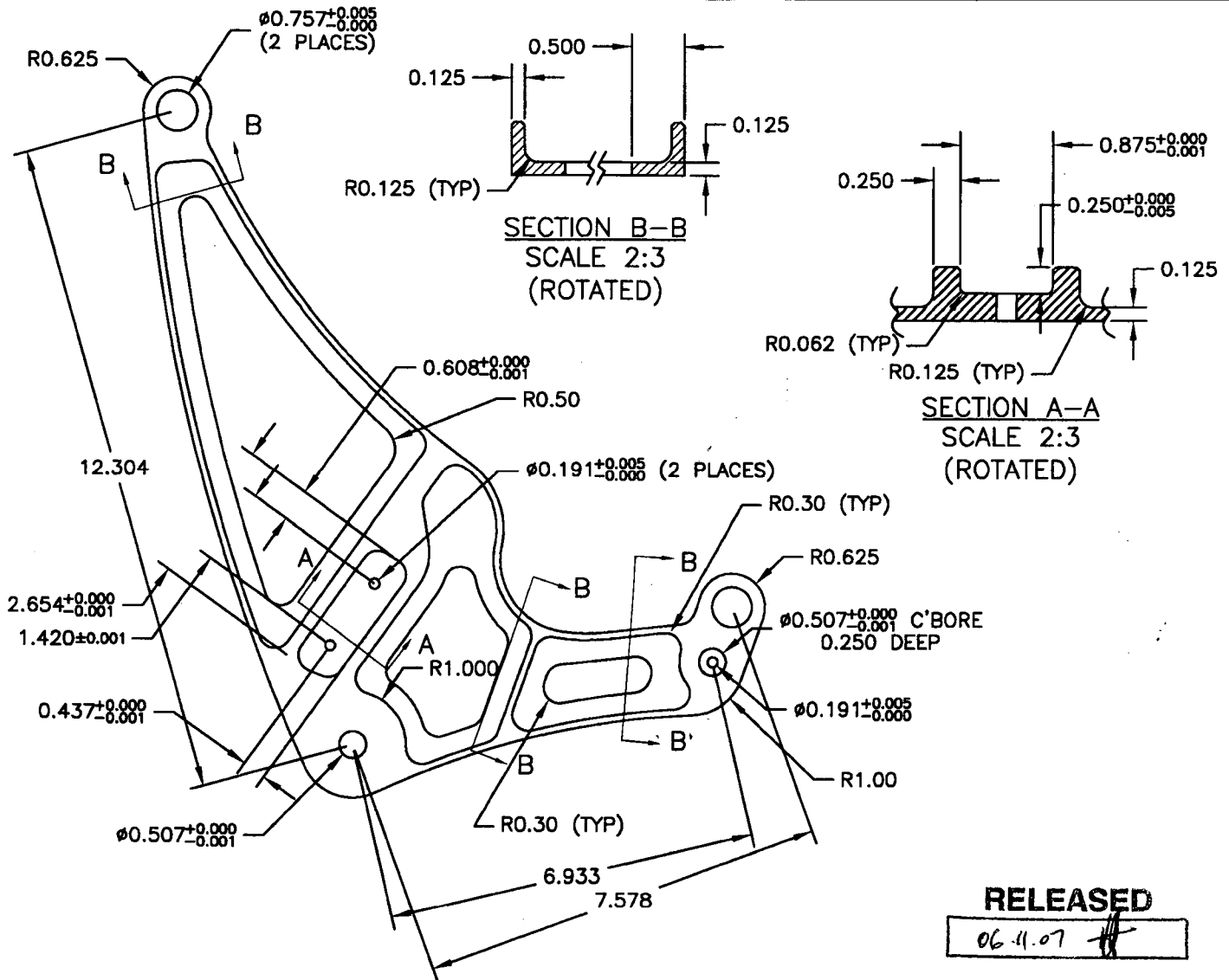
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN CP		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET			SCALE 1:3
A	00.11.07		NEW ISSUE		
B	04.11.22		ADD CUTOUTS & -043/-044		
C	06.10.16		CHANGE GEOM. TO ADD CLEARANCE		

**RELEASED**

06.11.07 #

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

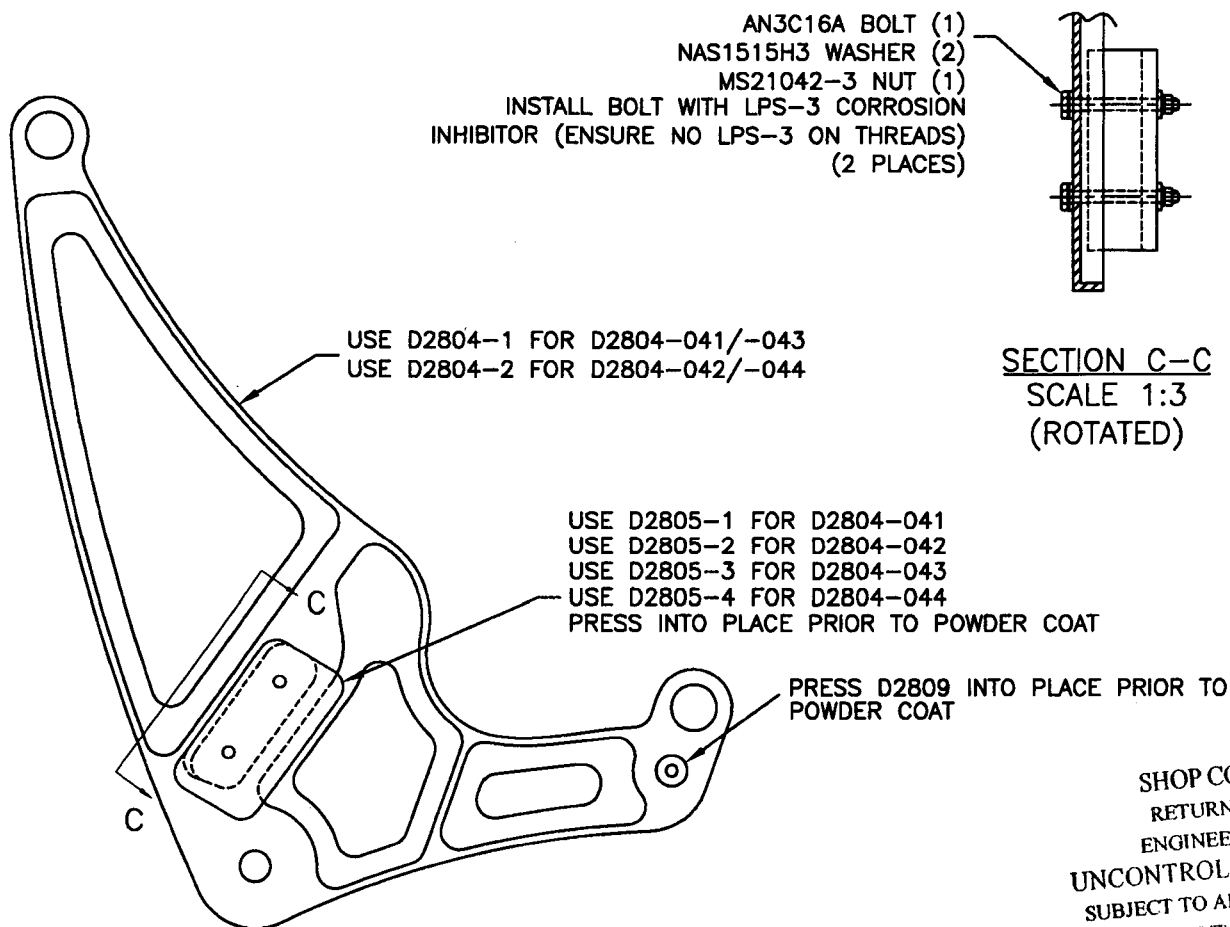
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 14551

**Copyright © 2000 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *44551*  
**RELEASED**

**D2804-041/-043 BRACKET ASS'Y (SHOWN).**  
**D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.